

Date: Tuesday, 8/1/2006 11:29:48 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRUT
 Job Number : 28064
 Estimate Number : 11221
 P.O. Number : N/A Part Number : D3350041
 This Issue : 8/1/2006 S.O. No. : N/A Drawing Number : D3350 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : N/A Material : N/A
 Written By : Due Date : 8/18/2006 Qty: 6 Um: Each
 Checked & Approved By : *JA 06 08 01*
 Comment : Est:B 05-07.11 Powder Coat now done after assembly KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0750X00750 6061-T6 Bar .75" x .75"



Comment: Qty.: 1.3234 f(s)/Unit Total: 7.9405 f(s)
 6061-T6 Bar .75" x .75"
 Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)
 (M6061T6B0.750x00.750)
 Identify for D3350-1
 Batch: *M100742*

Inf 06/08/20 6

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank: 0.750" x 0.750" x 15.00" long

Inf 06/08/20 6

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine D3350-1 as per Folio FA496 and Dwg D3350
 Identify as D3350-1

Inf 06/08/20 6

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Inf 06/08/20 6

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Er 06/08/20 x6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and Deburr

ml 06/08/20

6

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

gun 06-08-22

6

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AP 06/08/23

6

9.0

D23245

Strap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Strap

Pick:

Qty Part Number Description Batch

2 D2324-5 Strap *B 25048*

10.0

AN312A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3-12A Bolt *m18310*

11.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

2 AN960JD10 Washer *m100743*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/08/28

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:29:48 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 28064

Part Number: D3350041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

m100094

MF 06/08/23

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3350.

Identify as D3350-041 and batch number using a fine point permanent marker

MF 06/08/23 (6)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/08/24 (6)

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

am 06-08-28

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RB 6/1/28 (6)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5163

RB 06/08/28 (6)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/08/28 (6)

Job Completion



C 206108 128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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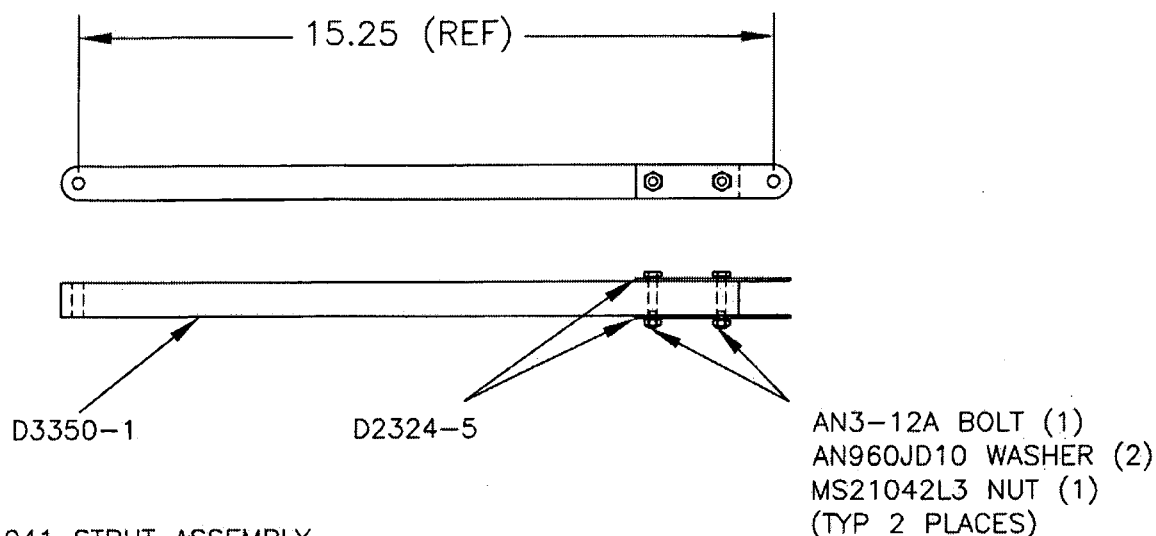
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

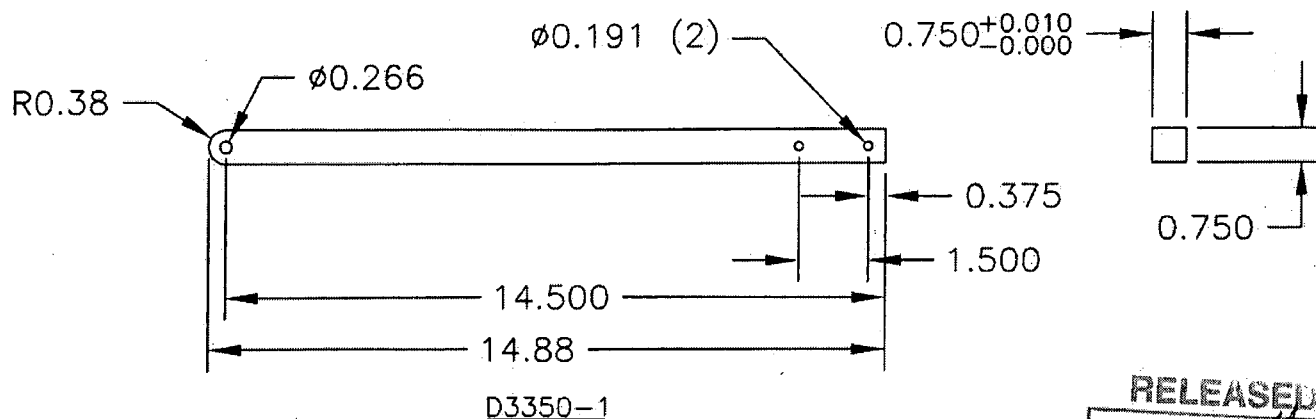


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3350	REV. A SHEET 1 OF 1
DATE 04.11.12		TITLE STRUT	SCALE 1:4
A	04.11.12	NEW ISSUE	



D3350-041 STRUT ASSEMBLY

- 1) IDENTIFY WITH DART P/N D3350-041 USING FINE POINT PERMANENT INK MARKER



D3350-1

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

RELEASED
04.12.16

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NO. 28064

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